

1503

W/O SPLIT

DART AEROSPACE LTD	Work Order:	22033A
Description: Bracket	Part Number:	D3264-1
Dwg: D3264 Rev. A	Qty:	15 4
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HA	04.12.08	15
2	MV	Cut blanks: 4.500" x 1.250" x 5.700" long Bar Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick (M6061T6B1.250x04.500) Identify for D3264-1 Batch: M16391	Er	04/12/16	15 4
3	MV	Machine as per Folio FA447 and Dwg D3264 Identify as D3264-1	Er	04/12/20	4
4	QC2	Inspect parts as they come off the CNC machine	Er	04/12/20	4
5	QC8	Second check	Er	05.01.14	4
6	MV	Deburr	Er	05.01.14	4
7	QC5	Inspect work to Step 6	Er	05.01.14	4
8	FP	Chemical Conversion Coat as per QSI 005 4.1	MM	05.01.15	4
9	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	MM	05.01.17	4
10	QC3	Inspect Powder Coat	CL	05/01/17	4
11	ST	Identify and Stock <i>Identify with part; Batch M16391 AFTER IDENTIFICATION</i>	CL	05/01/17	4
12	AC	Cost / part 20.15	Syc	05.01.18	4
13	DC	Close W/O 20.15 Inspect Level 21	HA	05.01.24	4

Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	

RELEASED
11/04/0907

144.78

DART AEROSPACE LTD		Work Order:	22033
Description: Bracket		Part Number:	D3264-1
Inspection Dwg: D3264	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	0.687	-		vern	
0.063	+/-0.010	0.061	-		vern	
0.125	+/-0.010	0.130	-		mic	
0.875	+/-0.010	0.877	-		mic	
0.062	+/-0.010	0.068	-		vern	
R0.03	+/-0.030	0.030	-		R.g	
R0.13	+/-0.030	0.125	-		R.g	
1.00	+/-0.030	1.000	-		mic	
0.125	+/-0.010	0.125	-		mic	
0.600	+/-0.010	0.601	-		vern	
R0.38	+/-0.030					cannot find dim
4.000	+/-0.005	4.004	-		vern	
0.750	+/-0.010	0.754	-		vern	
Ø0.208	+0.005/-0.000	0.194	-		vern	
Ø0.194						
5.50	+/-0.030	5.505	-		vern	
1.27	+/-0.030					cannot find dim
0.125	+/-0.010	0.127	-		mic	
0.063	+/-0.010	0.067	-			
R0.25	+/-0.030	0.250	-		R.g	
4.27	+/-0.030	4.272	-			
R0.30	+/-0.030	0.30	-		R.g	

Measured by: <i>EP</i>	Audited by: <i>BE</i>	Prototype Approval:	N/A
Date: 04/12/20	Date: 05.01.20	Date:	N/A

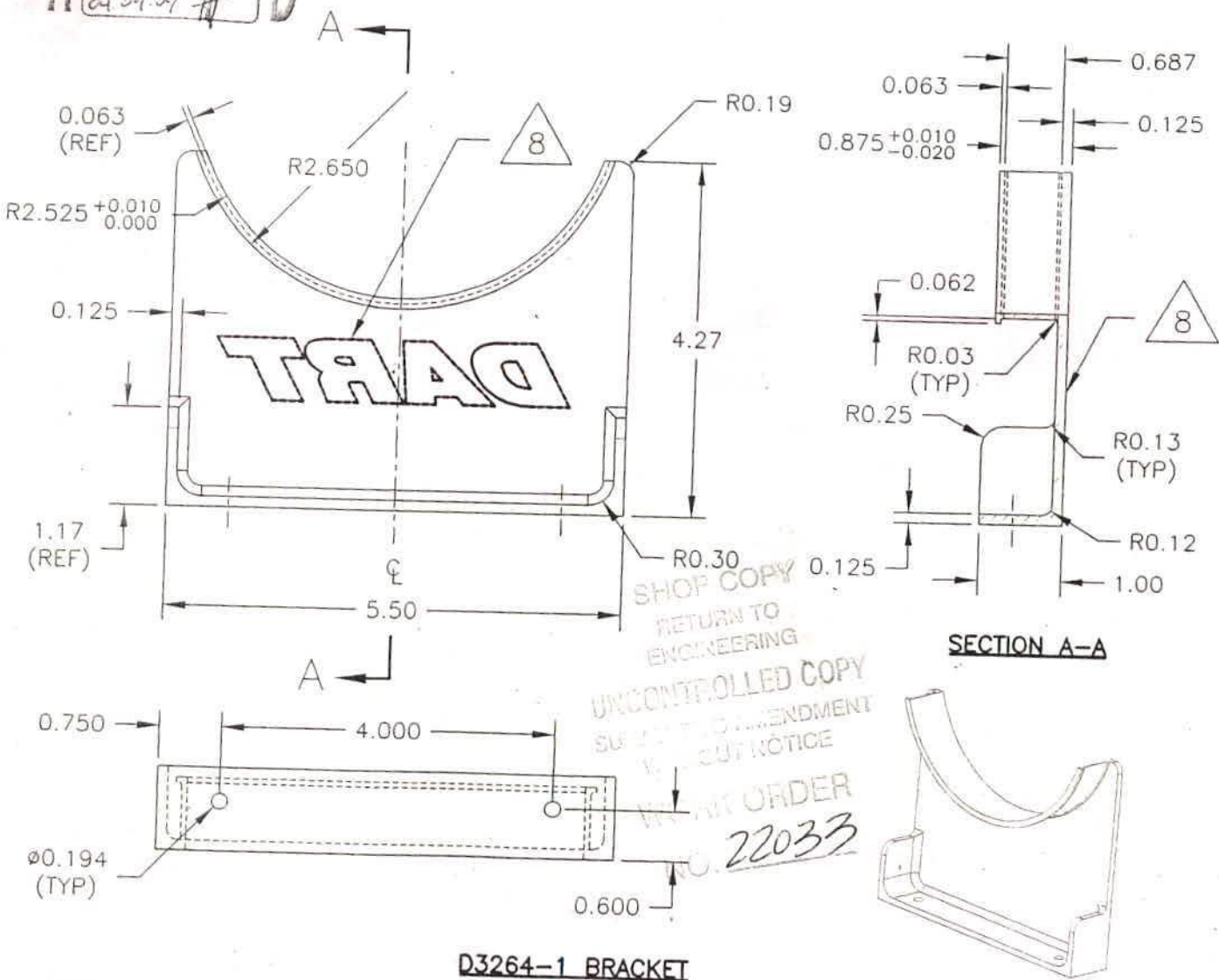
Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	<i>[Signature]</i>

RELEASED
04.07.08



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20		TITLE BRACKET	SCALE 1:2
A	04.04.20	NEW ISSUE	

RELEASED
04.04.20 #



D3264-1 BRACKET

D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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